


Work Order ID **77107**

**\*77107\***

Page 1

Friday, November 25, 2011 12:40:42 PM

Item ID: D3186-2M Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: SPACEPOD DOOR RH  
 Start Date: 11/25/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/9/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

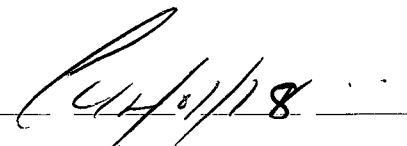
Approvals: Process Plan:  Date: 11/11/25 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3186	Rev E								

100 PURCHASING 0.00  
**\*100\***  
 Purchasing Memo 0.00  
 Purchasing Issue P/O: 155410  
 Description: D3186-2MDoor  
 Supplier: Delastek  
 Conformity Certificate and Process sheet required  
 Ship 3 Items from Previous steps

 11-11-25

110 Receive & Inspect for Damage & Mat'l Certs 0.00  
**\*110\***  
 Packaging Memo 0.00  
 Packaging Ensure a copy of certification of conformity and process sheet from Delastek is attached.

 11/18

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 77107

\*77107\*

Page 2

Friday, November 25, 2011 12:40:42 PM

Item ID: D3186-2M

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: SPACEPOD DOOR RH

Start Date: 11/25/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Run Start

\*NR1\*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

\*NR2\*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00

\*120\*

QC

Memo

0.00

Quality Control

Check for void spot and pins.

12-02-07 (1)

130

Identify as per dwg & Stock Location: *Campos*

0.00

\*130\*

Packaging

Memo

0.00

Packaging

12-02-07

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

12/2/11

R12-02-7

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, November 25, 2011 12:40:47 PM

Page 1

Work Order ID: 77107

**\*77107\***

Parent Item: D3186-2M

**\*D3186-2M\***

Parent Item Name: SPACEPOD DOOR RH

Start Date: 11/25/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec  
IPP rev D rv D dwg 07.03.07 ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3186-2P

Purchased

No

110

Each

0.0000

1

1

**\*D3186-2P\***

Spacepod Door

377107

\*\*

*Per 11/25/11*

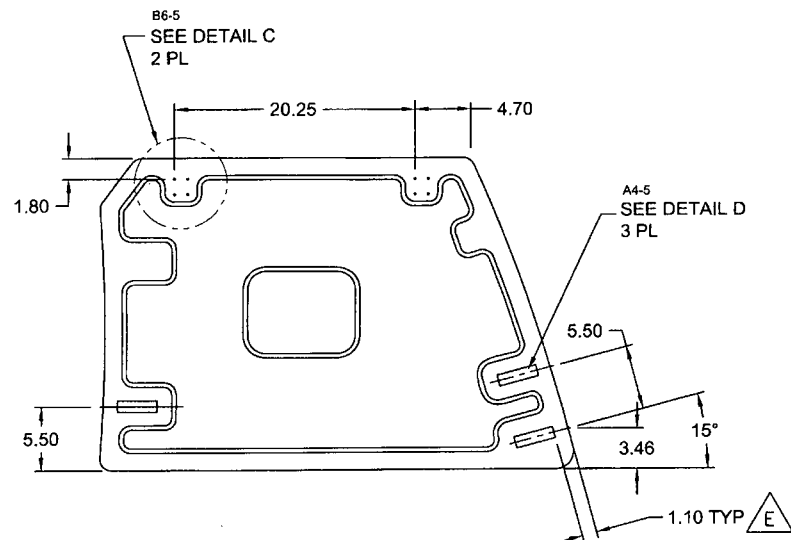
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

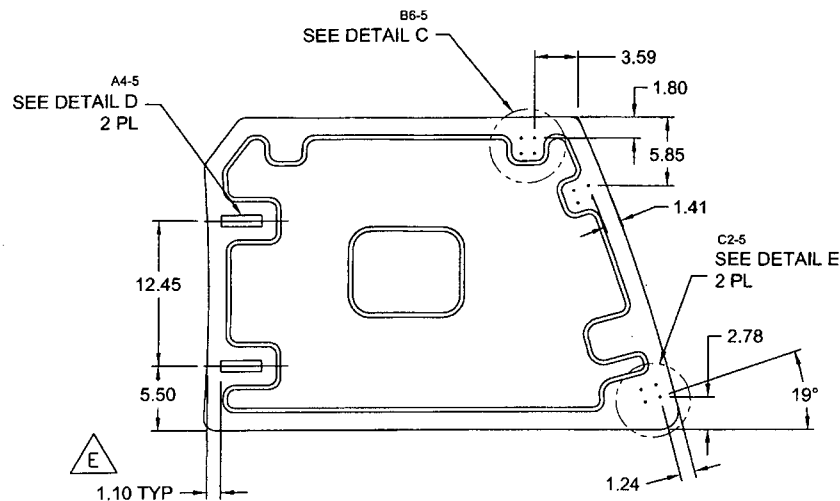
NOTE: Date & initial all entries



**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A



**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**RELEASED**  
2009-09-09

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHIN 10 WORKING DAYS  
NO. 77107

*211-11-25*

REV.	DESCRIPTION	BY	DATE
E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

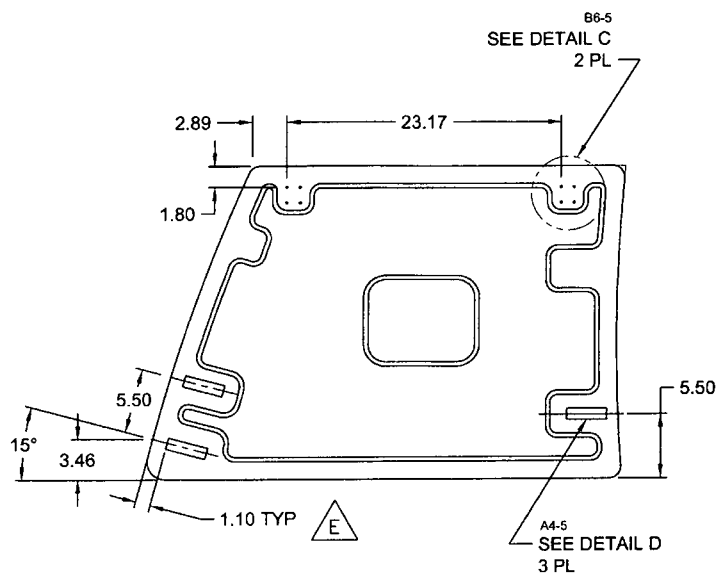
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

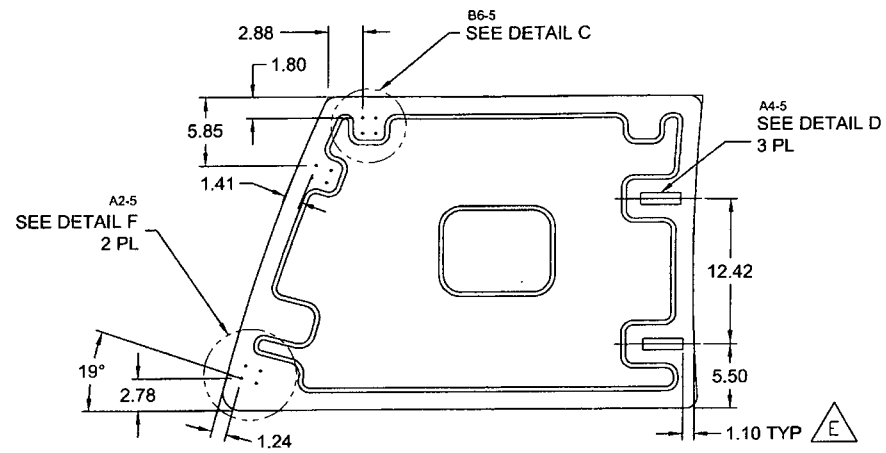
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





**D3186-2 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M



**D3186-4 SPACEPOD DOOR, RH**  
MAKE FROM D3186-2M

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

77107

**RELEASED**  
2008-09-09

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3186	REV. E SHEET 2 OF 5
MFG. APPR.	<i>[Signature]</i>	TITLE SPACEPOD DOOR	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	09.07.08		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# MAIN LAYUP

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)

FOAM

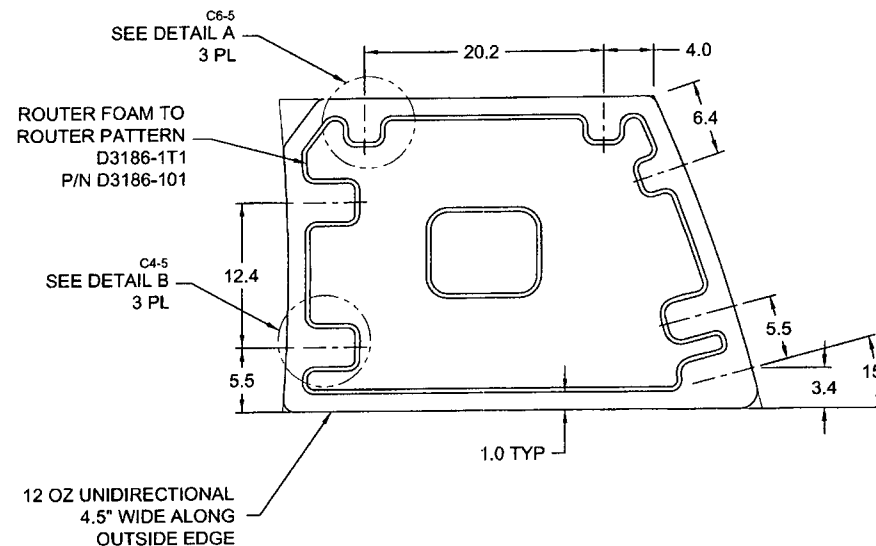
9 OZ SATIN (9 SQ FEET)

12 OZ UNIDIRECTIONAL

9 OZ SATIN (9 SQ FEET)

RESIN (35-45% BY WEIGHT)

PEEL PLY



**D3186-1M SPACEPOD DOOR AS MOLDED**

## NOTES:

### 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL

FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")

12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")

LAMINATE PER DART QSI 006 4.0

LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 7.0 lbs

8) USE MOLD DT8005 FOR DOOR LAYUP

**RELEASED**  
2009-08-08

DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. E
MFG. APPR.		D3186	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD DOOR	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

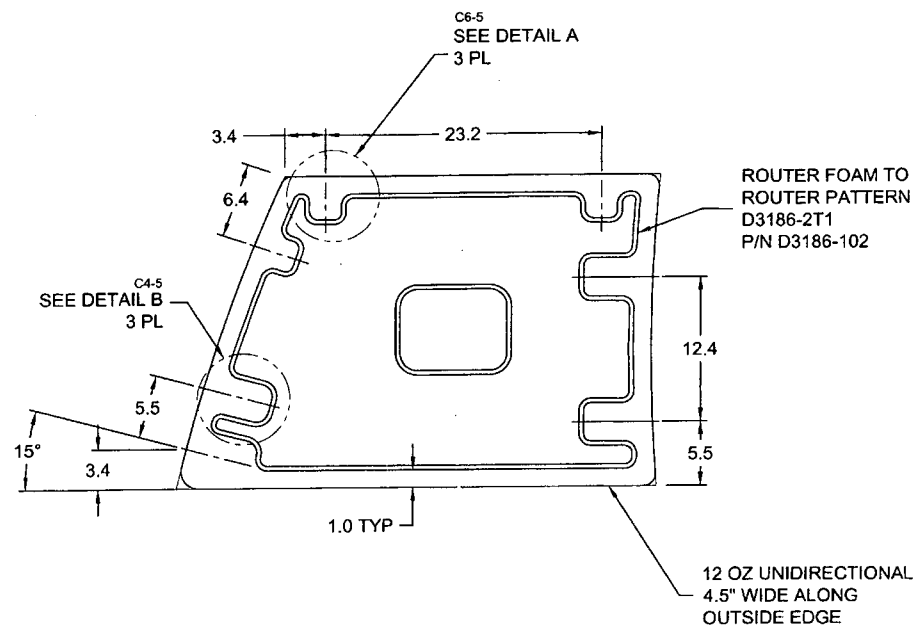
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

9 OZ SATIN (9 SQ FEET)  
9 OZ SATIN (9 SQ FEET)  
FOAM  
9 OZ SATIN (9 SQ FEET)  
12 OZ UNIDIRECTIONAL  
9 OZ SATIN (9 SQ FEET)  
RESIN (35-45% BY WEIGHT)  
PEEL PLY



1) MATERIAL:

- RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
LAMINATE PER DART QSI 006 4.0  
LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT: 7.0 lbs  
8) USE MOLD DT8006 FOR DOOR LAYUP

**D3186-2M SPACEPOD DOOR AS MOLDED**

RELEASED  
2009-09-09

77107

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	RF	DRAWING NO.	REV. 1
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NT
DATE 09.07.08		COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND NOT TO BE SUPPLIED TO THE PRESSURE CONTAINER TRADING COMPANY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. THIS DOCUMENT IS NOT FOR PURCHASE OR FOR COMMUNICATIONS TO ANY OTHER PERSON OR ENTITY.	

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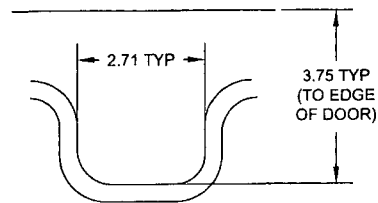
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

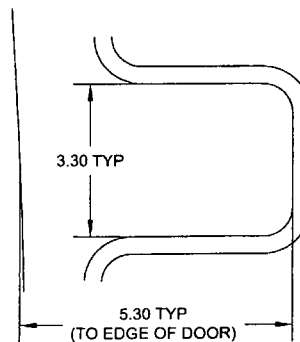
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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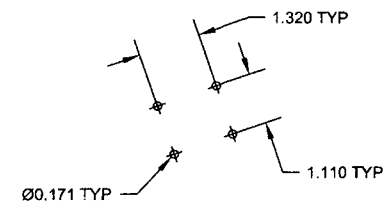
**NOTE:** Date & initial all entries



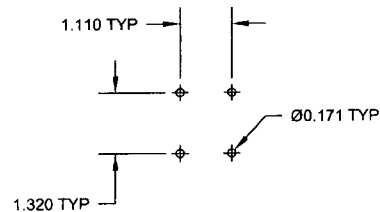
**DETAIL A**  
SCALE 4X  
D6-3  
D4-4



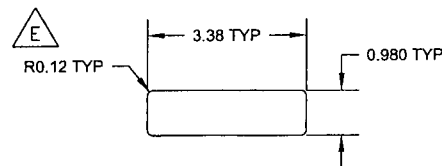
**DETAIL B**  
SCALE 4X  
C6-3  
C6-4



**DETAIL E**  
SCALE 4X  
C1-1

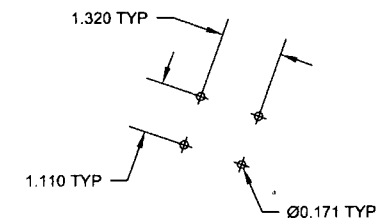


**DETAIL C**  
SCALE 4X  
D7-1  
D3-1  
D6-2  
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D**  
SCALE 4X  
C5-1  
D4-1  
B6-2  
C2-2



**DETAIL F**  
SCALE 4X  
C4-2

**RELEASED**  
2009-09-09

77107

DESIGN	DS	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Y	DRAWING NO.	REV. E
MFG. APPR.	MP	D3186	SHEET 5 OF 5
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	41841
Customer #	DART US

Telephone: (819) 533-5788

Warehouse: MAIN

**Bill to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

**Ship to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via <b>PZ</b>		F.O.B.		Terms		Salesperson	
FEDEX <del>Econo</del> Collect		Origin		Net 30 days USA		Claude Lessard, ext: 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST#	
16/01/2012	28/11/2011	19399	Brigitte Golden		PO15540		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC134-0060	Line #2 N° D3186-2P Spacepod Door RH B77107 U de M : Each Dwg. D3186 Rév.: E  No. série : B77107      No. lot 37497			

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

☒ Cust.    ☐ Adm.    ☐ Quality    ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Mardi, 2011-11-29 13:06:50  
 Utilisateur: Pascal Carignan

## Feuille de Procédé

Client	: DART US DART AEROSPACE LTD	Nom Dessin	: SPACEPOD DOOR RH
Numéro Job	: 37497	Numéro Article	: DKC134-0060
Numéro Soumission	: 3769	Numéro Dessin	: D3186
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2011-11-29 No. B.V. :	Révision dessin	: E
Prsht Rev.	: NC	Matériel	: 7781 & 411-350
Prem. fois	: -- Type :	Date Due	: 2011-12-06
Job précédente	: 36774	Qté:	1 UdM: UNITE
Écrit par	:		
Vérifié & Approuvé par	:		
Commentaires	: N° de pièce Client: D3186-2M		



# B 77107

 Process Sheet Rév.: 02 Modifier le N° de projet DK-359 pour  
 DK-362, AAC1885 était AC0883, AAC1887 était AC0884.

## Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0	AAC1616	N° 83634, Frekote Loctite Wolo
-----	---------	--------------------------------

Commentair Qty.:	0.050 UNITE(s)/Unit	Total :	0.050 UNITE(s)
------------------	---------------------	---------	----------------

N° 83634, Frekote Loctite Wolo

N° de Lot:

N/A

2.0	PRÉPARATION	Préparation du moule
-----	-------------	----------------------



Commentair Setup:	0.00Hrs/ Run: 5.0000Min	Total Run :	0.0833Hrs
-------------------	-------------------------	-------------	-----------

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0	AAC1885	Tissu à délaminer Release ply B
-----	---------	---------------------------------

Commentair Qty.:	3.28 VERGE(s)/Unit	Total :	3.28 VERGE(s)
------------------	--------------------	---------	---------------

Tissu à délaminer Release ply B

# de Lot:

1-30217-1

4.0	AAC1887	Wrightlon 5200 Bleu P3
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Commentair Qty.:	3.59 VERGE(s)/Unit	Total :	3.59 VERGE(s)
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Wrightlon 5200 Bleu P3

# de Lot:

N/A



5.0	AC0885	Feutre de drainage N° Airweave N 10
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Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
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6.0	AC0943	Stretchlon 200 poche à vide Vert
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Commentair Qty.:	3.00 VERGE(s)/Unit	Total :	3.00 VERGE(s)
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7.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
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Commentair Qty.:	4.5 VERGE(s)/Unit	Total :	4.5 VERGE(s)
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9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot:

1-31000-2

Date: Mardi, 2011-11-29 13:06:50  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 37497

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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8.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
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Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total : 2.2500 ROULEAU(s)

9.0	AMB0349	Fiberglass 12 oz Unidirectional
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Commentair Qty.: 1.00 VERGE(s)/Unit Total : 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

10.0	PREP-GENERAL	Préparation du matériel
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Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 30-11-11 Sceau:



11.0	AMB0286	Catalyst N° DDM-9
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Commentair Qty.: 0.0080 GALLON(s)/Unit Total : 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

12.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
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Commentair Qty.: 0.500 LITRE(s)/Unit Total : 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-32912-1

13.0	PREP-GENERAL	Préparation du matériel
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 2/12/11 Sceau:



14.0	LAMINAGE	Faire le laminage
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 2/12/11 Sceau:



Date: Mardi, 2011-11-29 13:06:50  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 37497

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

15.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 9:30

Heure Fin Curing: 8:00

Date: 2/12/11 sceau:



16.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total: 0.0120 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total: 0.300 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-33219-1

18.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 5/12/11 Sceau:



19.0 DKC134-0057 Foam Core N° D3186-102 ( Porte D3186-2 )

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)  
Foam Core N° D3186-102 ( Porte D3186-2 ) N° de Job: 37578

20.0 AAC1611 Polybond B46F

Commentair Qty.: 0.090 KIT(s)/Unit Total: 0.090 KIT(s)  
Polybond B46F N° de Lot: 1-27295-1

21.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )

Date: Mardi, 2011-11-29 13:06:50  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 37497

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin et selon les lignes de positionnement prévues à cet effet.

Date: 07-12-11 Sceau:



22.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 8.30

Heure Fin Curing: 9.00

Date: 7-12-11 sceau:



23.0

AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-33219-1

25.0

PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio.1.5% catalyst par quantité de résine.

Date: 8/12/11 Sceau:



26.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 8/12/11 Sceau:



Date: Mardi, 2011-11-29 13:06:50  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 37497

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 12:50 Heure Fin Curing: 8:50

Date: 8/12/11 sceau:



28.0 DÉMOULAGE Démoulage de la pièce



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 9/12/11 Sceau:



29.0 TRIMAGE Trimage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 9/12/11 Sceau:



30.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-31117-3

31.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-31394-2

32.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 12 dec 11 Sceau:



# de fiche de mélange: N/A 2<sup>e</sup> côté  
1<sup>er</sup> côté

Date: Mardi, 2011-11-29 13:06:50  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 37497

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

33.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler N° de Lot: 1-33224-1

34.0 FINITION Finition Générale



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Date: 12-12-11 Sceau:



35.0 AAC1021 Dupont Primer N° 7704S

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-31117-3

36.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-31394-2

37.0 PRIMER Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 13 dec 11 Sceau: 35 # de Fiche de mélange: N/A 2<sup>e</sup> côté 1<sup>er</sup> côté



38.0 INSPEC FINAL Inspection finale



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 13 DEC. 2011 Sceau:



39.0 EMBAL / ENTREPO Emballage & Entreposage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: DEC 14 2011 Sceau:

